

Date: Tuesday, 9/25/2007 10:14:20 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, INBOARD, LS, 206
Job Number	: 34859		
Estimate Number	: 10820		
P.O. Number	:	Part Number	: D26661
This Issue	: 9/25/2007 S.O. No. :	Drawing Number	: D2666 REV. D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: D
Previous Run	: 33797	Material	:
Written By	:	Due Date	: 10/10/2007 Qty: 12 Um: Each
Checked & Approved By	: <u>07.09.25</u>		
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 2X6X6.25
Issue material from stock:
Cut Size 2.0 x 6.25 X 6.0
Grain Along Long 6.0 Length

Batch No: 134872

SP 08/02/01

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program batch number.
1-Inspect part number and batch number are programmed correctly.
2-Fixturing Inspection last completed on 3/1/05 by A.P.
3-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
6-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
8-Machine Step No.3 of Folio and visually inspect as per attached Dimension Sheet
9- Deburr

DSP 08/02/02

SP 08/02/01

(13)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

DSP 08/02/04

(13)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DSP 08/02/02

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2666-1 PAR #: N/A Fault Category: Prod / machine NCR: Yes No DQA: 1 Date: 08/02/08
 QA: N/C Closed: 1 Date: 08 02 08

NCR: <u>34859</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A -	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/04	2.0	The billet was not squared in prog. #2661 RC. origine was wrong	CP 08.02.05 pu 08/042	Moved origine Scrap and destroy QM (D) B# 34872	DSP 08/02/04	08/02/04	CP 08.02.05 pu 08/042	08/02/04
08/02/04	2.0	The billet was not squared in prog. #2661 RC. origine was wrong	CP 08.02.05 pu 08/042	Moved origine Part is acceptable	DSP 08/02/04	08/02/05	CP 08.02.05 pu 08/042	08/02/05
08/02/04	2.0	5 First parts; the 0.3160 holes are over tol. by 0.002". 1 part have groove from chamfer tool on the Skid Bolt island	CP 08.02.04 pu 08/042	Changed the drill; PARTS ACCEPTABLE	DSP 08/02/04	08/02/05	CP 08.02.04 pu 08/042	08/02/05

NOTE: Date & initial all entries

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Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 34859

Part Number: D26661

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08-02-06 (B)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.H. 08/02/06

(13X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M106379

FL 08/02/07 (13)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M.H. 08/02/07

(13X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST426

AS 08/02/07 (13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 08/02/08

(13)

Job Completion



mini 2008/2/07 (13)

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34859
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.135	0.137	0.1365	0.134		
B	0.100	0.140		0.130	0.1295	0.130	0.127		
C	2.470	2.510		2.490	2.495	2.495	2.492		
D	0.100	0.180		0.144	0.144	0.142	0.144		
E	0.210	0.230		0.221	0.223	0.222	0.222		
F	1.313	1.343		1.325	1.325	1.325	1.325		
G	0.240	0.260		0.251	0.250	0.249	0.248		
H	0.615	0.685		0.649	0.675	0.675	0.680		
I	1.125	1.145		1.138	1.138	1.138	1.142		
J	0.990	1.010		1.009	1.007	1.008	1.0075		
K	0.235	0.240		0.237	0.239	0.238	0.237		
L	0.510	0.515		0.510	0.510	0.510	0.511		
M	0.100	0.120		0.109	0.108	0.105	0.105		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.25	1.25	1.25	1.25		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		0.500	0.500	0.500	0.500		
S	0.313	0.318		0.315	0.315	0.315	0.315		
T	2.495	2.505		2.501	2.500	2.500	2.500		
U	1.357	1.367		1.355	1.360	1.360	1.361		
V	0.315	0.322		0.324	0.324	0.324	0.324		
W	0.540	0.560		0.550	0.545	0.543	0.554		
X	1.674	1.684		1.680	1.678	1.678	1.678		
Y	0.257	0.262		0.258	0.259	0.2585	0.259		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	DJP
Date:	08/02/02

Audited by:	[Signature]
Date:	08.02.06

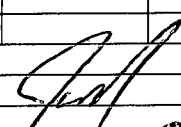
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	[Signature]


DART AEROSPACE LTD	Work Order:	34859
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.100	0.140		0.138	0.138	0.138	0.138		
B	0.100	0.140		0.127	0.126	0.1265	0.127		
C	2.470	2.510		2.493	2.494	2.494	2.494		
D	0.100	0.180		0.145	0.145	0.145	0.145		
E	0.210	0.230		0.221	0.221	0.221	0.221		
F	1.313	1.343		1.325	1.325	1.325	1.325		
G	0.240	0.260		0.248	0.248	0.248	0.248		
H	0.615	0.685		0.680	0.680	0.680	0.680		
I	1.125	1.145		0.145	1.145	1.145	1.145		
J	0.990	1.010		1.0075	1.0075	1.008	1.0075		
K	0.235	0.240		0.237	0.237	0.237	0.237		
L	0.510	0.515		0.511	0.511	0.511	0.511		
M	0.100	0.120		0.105	0.105	0.105	0.105		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		0.500	0.500	0.500	0.500		
S	0.313	0.318		0.315	0.315	0.315	0.315		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.361	1.361	1.361	1.3615		
V	0.315	0.322		0.324	0.320	0.320	0.320		
W	0.540	0.560		0.555	0.555	0.555	0.555		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		0.259	0.259	0.259	0.259		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	DJP
Date:	08/02/03

Audited by:	
Date:	08.02.06

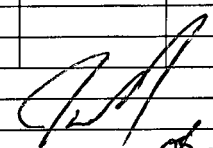
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

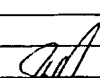
DART AEROSPACE LTD	Work Order: 34859
Description: 206 Saddle, Inboard, Left side	Part Number: D2666-1
Inspection Dwg: D2666 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

13				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	11	12		
A	0.100	0.140	.138	0.138	0.138	0.138	0.138		
B	0.100	0.140	.126	0.126	0.126	0.126	0.126		
C	2.470	2.510	2.500	2.494	2.494	2.494	2.494		
D	0.100	0.180	.140	0.140	0.140	0.140	0.140		
E	0.210	0.230	.221	0.221	0.221	0.221	0.222		
F	1.313	1.343	1.325	1.325	1.325	1.325	1.325		
G	0.240	0.260	.248	0.248	0.255	0.2543	0.254		
H	0.615	0.685	.680	0.680	0.670	0.672	0.672		
I	1.125	1.145	1.145	1.145	1.141	1.143	1.143		
J	0.990	1.010	1.008	1.008	1.008	1.008	1.008		
K	0.235	0.240	.237	0.237	0.2365	0.237	0.237		
L	0.510	0.515	.511	0.511	0.511	0.511	0.511		
M	0.100	0.120	.105	0.105	0.105	0.105	0.105		
N	1.565	1.585	1.575	1.575	1.575	1.575	1.575		
O	5.990	6.010	6.001	6.001	6.001	6.001	6.001		
P	1.245	1.255	1.250	1.25	1.260	1.25	1.25		
Q	2.495	2.505	2.500	2.500	2.500	2.500	2.500		
R	0.490	0.510	.500	0.500	0.500	0.500	0.500		
S	0.313	0.318	.315	.315	0.315	.315	.315		
T	2.495	2.505	2.500	2.5	2.500	2.500	2.500		
U	1.357	1.367	1.361	1.361	1.361	1.361	1.361		
V	0.315	0.322	.320	.320	0.320	.320	.320		
W	0.540	0.560	.555	0.555	0.553	0.554	0.554		
X	1.674	1.684	1.678	1.678	1.678	1.678	1.678		
Y	0.257	0.262	.259	0.259	0.259	0.259	0.259		
Z	0.178	0.198	.188	.188	0.189	.188	0.188		
AA									
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AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DJP
Date: 08/02/04

Audited by: 
Date: 08.02.04

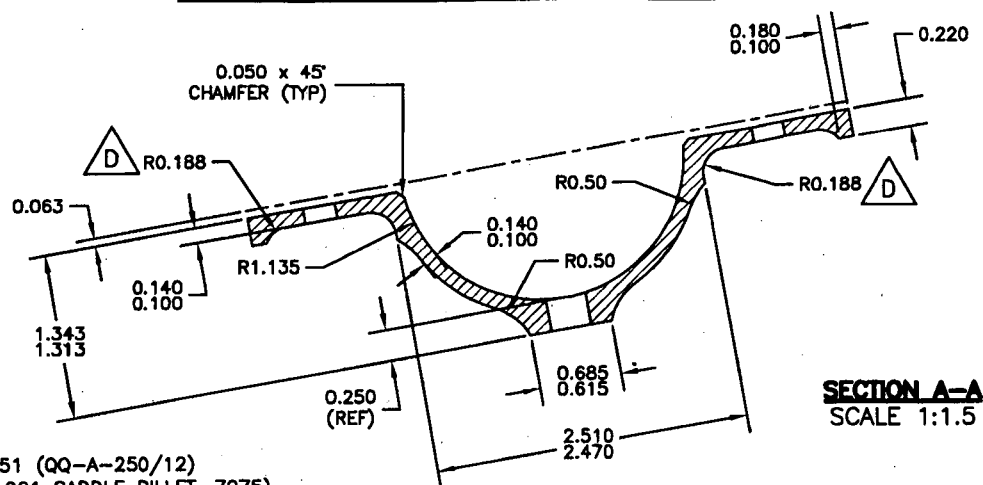
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A		New Issue	RF	
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D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

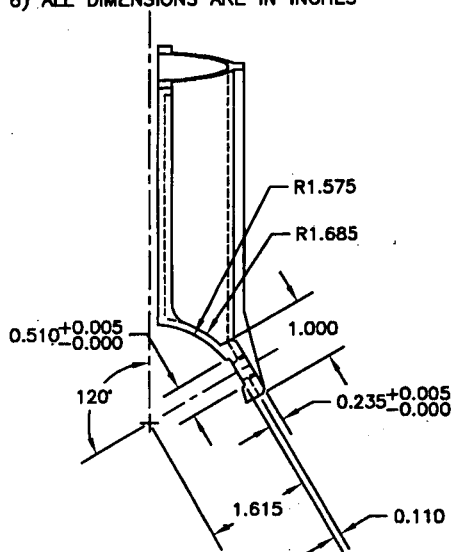
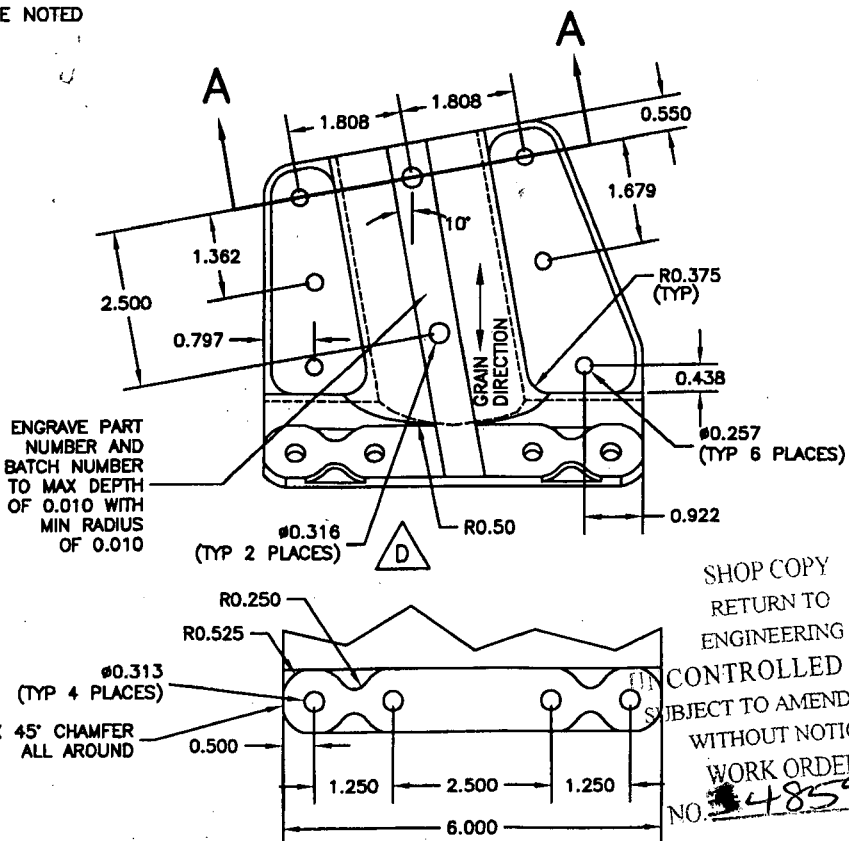
RELEASED

07.02.12 [Signature]



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4859

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